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09658407 .091100

APPLICATION FOR

UNITED STATES LETTERS PATENT

FOR

CLOSED LOOP ADDITIVE INJECTION AND MONITORING SYSTEM FOR OILFIELD OPERATIONS

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CLOSED LOOP ADDITIVE INJECTION AND MONITORING SYSTEM FOR OILFIELD OPERATIONS

BACKGROUND OF THE INVENTION

1. Related Applications

This application is a continuation-in-part of United States Provisional Patent Application Ser. No. 60/153,175 filed on September 10, 1999 and United States Patent Application Ser. No. 09/218,067 filed on December 21, 1998 now pending.

2. Field of the Invention

This invention relates generally to oilfield operations and more particularly to a remotely/network-controlled additive injection system for injecting precise amounts of additives or chemicals into wellbores, wellsite hydrocarbon processing units, pipelines, and chemical processing units.

3. Background of the Art

A variety of chemicals (also referred to herein as "additives") are

often introduced into producing wells, wellsite hydrocarbon processing units, oil and gas pipelines and chemical processing units to control, among other things, corrosion, scale, paraffin, emulsion, hydrates, hydrogen sulfide, asphaltenes and formation of other harmful chemicals. In oilfield production wells, additives are usually injected through a tubing (also referred to herein as "conductor line") that is run from the surface to a known depth. Additives are introduced in connection with electrical submersible pumps (as shown for example in U.S. Patent No. 4,582,131 which is assigned to the assignee hereof and incorporated herein by reference) or through an auxiliary tubing associated with a power cable used with the electrical submersible pump (such as shown in U.S. Patent No. 5,528,824 (assigned to the assignee hereof and incorporated herein by reference). Injection of additives into fluid treatment apparatus at the well site and pipelines carrying produced hydrocarbons is also known.

For oil well applications, a high pressure pump is typically used to inject an additive into the well from a source thereof at the wellsite. The pump is usually set to operate continuously at a set speed or stroke length to control the amount of the injected additive. A separate pump and an injector are typically used for each type of additive. Manifolds are sometimes used to inject additives into multiple wells, production wells

are sometimes unmanned and are often located in remote areas or on substantially unmanned offshore platforms. A recent survey by Baker Hughes Incorporated of certain wellbores revealed that as many as thirty percent (30%) of the additive pumping systems at unmanned locations were either injecting incorrect amounts of the additives or were totally inoperative. Insufficient amounts of treatment additives can increase the formation of corrosion, scale, paraffins, emulsion, hydrates etc., thereby reducing hydrocarbon production, the operating life of the wellbore equipment and the life of the wellbore itself, requiring expensive rework operations or even the abandonment of the wellbore. Excessive corrosion in a pipeline, especially a subsea pipeline, can rupture the pipeline, contaminating the environment. Repairing subsea pipelines can be cost-prohibitive.

Commercially-used wellsite additive injection apparatus usually require periodic manual inspection to determine whether the additives are being dispensed correctly. It is important and economically beneficial to have additive injection systems which can supply precise amounts of additives and which systems are adapted to periodically or continuously monitor the actual amount of the additives being dispensed, determine the impact of the dispersed additives, vary the amount of dispersed additives

as needed to maintain certain desired parameters of interest within their respective desired ranges or at their desired values, communicate necessary information with offsite locations and take actions based in response to commands received from such offsite locations. The system should also include self-adjustment within defined parameters. Such a system should also be developed for monitoring and controlling additive injection into multiple wells in an oilfield or into multiple wells at a wellsite, such as an offshore production platform. Manual intervention at the wellsite of the system to set the system parameters and to address other operational requirements should also be available.

The present invention addresses the above-noted problems and provides a additive injection system which dispenses precise amounts of additives, monitors the dispensed amounts, communicates with remote locations, takes corrective actions locally, and/or in response to commands received from the remote locations.

4. SUMMARY OF THE INVENTION

In one embodiment the present invention provides a wellsite additive injection system that injects, monitors and controls the supply of additives into fluids recovered through wellbores, including with input from

remote locations as appropriate. The system includes a pump that supplies, under pressure, a selected additive from a source thereof at the wellsite into the wellbore via a suitable supply line. A flow meter in the supply line measures the flow rate of the additive and generates signals representative of the flow rate. A controller at the wellsite (wellsite or onsite controller) determines from the flow meter signals the additive flow rate, presents that rate on a display and controls the operation of the pump according to stored parameters in the controller and in response to command signals received from a remote location. The controller interfaces with a suitable two-way communication link and transmits signals and data representative of the flow rate and other relevant information to a second controller at a remote location preferably via an EIA-232 or EIA-485 communication interface. The remote controller may be a computer and may be used to transmit command signals to the wellsite controller representative of any change desired for the flow rate. The wellsite controller adjusts the flow rate of the additive to the wellbore to achieve the desired level of chemical additives.

The wellsite controller is preferably a microprocessor-based system and can be programmed to adjust the flow rate automatically when the calculated flow rate is outside predetermined limits provided to the

controller. The flow rate is increased when it falls below a lower limit and is decreased when it exceeds an upper limit. Also an embodiment of the present invention is a system wherein the controller can also switch between redundant pumps when the flow rate cannot be controlled with the pump then in-service.

The system of the present invention may be configured for multiple wells at a wellsite, such as an offshore platform. In one embodiment, such a system includes a separate pump, a fluid line and an onsite controller for each well. Alternatively, a suitable common onsite controller may be provided to communicate with and to control multiple wellsite pumps via addressable signaling. A separate flow meter for each pump provides signals representative of the flow rate for its associated pump to the onsite common controller. The onsite controller may be programmed to display the flow rates in any order as well as other relevant information. The onsite controller at least periodically polls each flow meter and performs the above-described functions. The common onsite controller transmits the flow rates and other relevant or desired information for each pump to a remote controller. The common onsite controller controls the operation of each pump in accordance with the stored parameters for each such pump and in response to instructions received from the remote

controller. If a common additive is used for a number of wells, a single additive source may be used. A single or common pump may also be used with a separate control valve in each supply line that is controlled by the controller to adjust their respective flow rates.

A suitable precision low-flow, flow meter is utilized to make precise measurements of the flow rate of the injected additive. Any positive displacement-type flow meter, including a rotating flow meter, may also be used. The onsite controller is environmentally sealed and can operate over a wide temperature range. The present system is adapted to port to a variety of software and communications protocols and may be retrofitted on the commonly used manual systems, existing process control systems, or through uniquely developed additive management systems developed independently or concurrently.

The additive injection of the present invention may also utilize a mixer wherein different additives are mixed or combined at the wellsite and the combined mixture is injected by a common pump and metered by a common meter. The onsite controller controls the amounts of the various additives into the mixer. The additive injection system may further include a plurality of sensors downhole which provide signals

representative of one or more parameters of interest relating to the characteristics of the produced fluid, such as the presence or formation of sulfites, hydrogen sulfide, paraffin, emulsion, scale, asphaltenes, hydrates, fluid flow rates from various perforated zones, flow rates through downhole valves, downhole pressures and any other desired parameter. The system may also include sensors or testers at the surface which provide information about the characteristics of the produced fluid. The measurements relating to these various parameters are provided to the wellsite controller which interacts with one or more models or programs provided to the controller or determines the amount of the various additives to be injected into the wellbore and/or into the surface fluid treatment unit and then causes the system to inject the correct amounts of such additives. In one aspect, the system continuously or periodically updates the models based on the various operating conditions and then controls the additive injection in response to the updated models. This provides a closed-loop system wherein static or dynamic models may be utilized to monitor and control the additive injection process.

The system of the present invention is equally applicable to monitoring and control of additive injection into oil and gas pipelines (e.g. drag reducer additive), wellsite fluid treatment units, and refining and

petrochemical chemical treatment applications.

The additives injected using the present invention are injected in very small amounts. Preferably, the flow rate for an additive injected using the present invention is at a rate such that the additive is present at a concentration of from about 1 parts per million (ppm) to about 10,000 ppm in the fluid being treated. More preferably, the flow rate for an additive injected using the present invention is at a rate such that the additive is present at a concentration of from about 1 ppm to about 500 ppm in the fluid being treated. Most preferably the flow rate for an additive injected using the present invention is at a rate such that the additive is present at a concentration of from about 10 ppm to about 400 ppm in the fluid being treated.

5. BRIEF DESCRIPTION OF THE DRAWINGS

For a detailed understanding of the present invention, reference should be made to the following detailed description of the preferred embodiments, taken in conjunction with the accompanying drawings, in which like elements have been given like numerals, wherein:

Figure 1 is a schematic illustration of a additive injection and monitoring system according to one embodiment of the present invention.

Figure 1A shows an alternative manner for controlling the operation of the chemical additive pump.

Figure 1B shows a circuit for providing a measure of manual control of the controller for additive injection pump **22**.

Figure 2 shows a functional diagram depicting one embodiment of the system for controlling and monitoring the injection of additives into multiple wellbores, utilizing a central controller on an addressable control bus.

Figure 3 is a schematic illustration of a wellsite additive injection system which responds to in-situ measurements of downhole and surface parameters of interests according to one embodiment of the present invention.

Figure 4 shows an alternative embodiment of the present invention wherein redundant additive pumps are used to inject additives.

6. DETAILED DESCRIPTION OF PREFERRED EMBODIMENTS

Figure 1 is a schematic diagram of a wellsite additive injection system **10** according to one embodiment of the present invention. The system **10**, in one aspect, is shown as injecting and monitoring of additives **13a** into a wellbore **50** and, in another aspect, injecting and monitoring of additives **13b** into a wellsite surface treatment or processing unit **75**. The wellbore **50** is shown to be a production well using typical completion equipment. The wellbore **50** has a production zone **52** which includes multiple perforations **54** through the formation **55**. Formation fluid **56** enters a production tubing **60** in the well **50** via perforations **54** and passages **62**. A screen **58** in the annulus **51** between the production tubing **60** and the formation **55** prevents the flow of solids into the production tubing **60** and also reduces the velocity of the formation fluid entering into the production tubing **60** to acceptable levels. An upper packer **64a** above the perforations **54** and a lower packer **64b** in the annulus **51** respectively isolate the production zone **52** from the annulus **51a** above and annulus **51b** below the production zone **52**. A flow control valve **66** in the production tubing **60** can be used to control the fluid flow to the surface **12**. A flow control valve **67** may be placed in the production tubing **62** below the perforations **54** to control fluid flow from

any production zone below the production zone **52**.

A smaller diameter tubing, such as tubing **68**, may be used to carry the fluid from the production zones to the surface. A production well usually includes a casing **40** near the surface and wellhead equipment **42** over the wellbore. The wellhead equipment generally includes a blow-out preventor stack **44** and passages for supplying fluids into the wellbore **50**. Valves (not shown) are provided to control fluid flow to the surface **12**. Wellhead equipment **42** and production well equipment, such as shown in the production well **60**, are well known and thus are not described in greater detail.

Referring back to **Figure 1**, in one aspect of the present invention, the desired additive **13a** from a source **16** thereof is injected into the wellbore **50** via an injection line **14** by a suitable pump, such as a positive displacement pump **18** ("additive pump"). The additive **13a** flows through the line **14** and discharges into the production tubing **60** near the production zone **52** via inlets or passages **15**. The same or different injection lines may be used to supply additives to different production zones. In **Figure 1**, line **14** is shown extending to a production zone below the zone **52**. Separate injection lines allow injection of different additives

at different well depths. The same also holds for injection of additives in pipelines or surface processing facilities.

A suitable high-precision, low-flow, flow meter **20** (such as gear-type meter or a nutating meter), measures the flow rate through line **14** and provides signals representative of the flow rate. The pump **18** is operated by a suitable device **22** such as a motor. The stroke of the pump **18** defines fluid volume output per stroke. The pump stroke and/or the pump speed are controlled, e.g., by a **4** - 20 milliamperes control signal to control the output of the pump **18**. The control of air supply controls a pneumatic pump.

In the present invention, an onsite controller **80** controls the operation of the pump **18**, either utilizing programs stored in a memory **91** associated with the wellsite controller **80** and/or instructions provided to the wellsite controller **80** from a remote controller or processor **82**. The wellsite controller **80** preferably includes a microprocessor **90**, resident memory **91** which may include read only memories (ROM) for storing programs, tables and models, and random access memories (RAM) for storing data. The microprocessor **90**, utilizing signals from the flow meter **20** received via line **21** and programs stored in the memory **91**

determining the flow rate of the additive and displays such flow rate on the display **81**. The wellsite controller **80** can be programmed to alter the pump speed, pump stroke or air supply to deliver the desired amount of the additive **13a**. The pump speed or stroke, as the case may be, is increased if the measured amount of the additive injected is less than the desired amount and decreased if the injected amount is greater than the desired amount. The onsite controller **80** also includes circuits and programs, generally designated by numeral **92** to provide interface with the onsite display **81** and to perform other functions.

The onsite controller **80** polls, at least periodically, the flow meter **20** and determines therefrom the additive injection flow rate and generates data/signals which are transmitted to a remote controller **82** via a data link **85**. Any suitable two-way data link **85** may be utilized. There also may be a data management system associated with the remote controller. Such data links may include, among others, telephone modems, radio frequency transmission, microwave transmission and satellites utilizing either EIA-232 or EIA-485 communications protocols (this allows the use of commercially available off-the-shelf equipment). The remote controller **82** is preferably a computer-based system and can transmit command signals to the controller **80** via the link **85**. The

remote controller **82** is provided with models/programs and can be operated manually and/or automatically to determine the desired amount of the additive to be injected. If the desired amount differs from the measured amount, it sends corresponding command signals to the wellsite controller **80**. The wellsite controller **80** receives the command signals and adjusts the flow rate of the additive **13a** into the well **50** accordingly. The remote controller **82** can also receive signals or information from other sources and utilize that information for additive pump control.

The onsite controller **80** preferably includes protocols so that the flow meter **20**, pump control device **22**, and data links **85** made by different manufacturers can be utilized in the system **10**. In the oil industry, the analog output for pump control is typically configured for 0-5 VDC or 4-20 milliampere (mA) signal. In one mode, the wellsite controller **80** can be programmed to operate for such output. This allows for the system **10** to be used with existing pump controllers. A suitable source of electrical power source **89**, e.g., a solar-powered DC or AC power unit, or an onsite generator provides power to the controller **80**, converter **83** and other electrical circuit elements. The wellsite controller **80** is also provided with a display **81** that displays the flow rates of the individual

flow meters. The display **81** may be scrolled by an operator to view any of the flow meter readings or other relevant information. The display **81** is controllable either by a signal from the remote controller **82** or by a suitable portable interface device **87** at the well site, such as an infrared device or a key pad. This allows the operator at the wellsite to view the displayed data in the controller **80** non-intrusively without removing the protective casing of the controller.

Still referring to **Figure 1**, the produced fluid **69** received at the surface is processed by a treatment unit or processing unit **75**. The surface processing unit **75** may be of the type that processes the fluid **69** to remove solids and certain other materials such as hydrogen sulfide, or that processes the fluid **69** to produce semi-refined to refined products. In such systems, it is desired to periodically or continuously inject certain additives. A system, such as system **10** shown in **Figure 1** can be used for injecting and monitoring additives into the treatment unit **75**.

In addition to the flow rate signals **21** from the flow meter **20**, the wellsite controller **80** may be configured to receive signals representative of other parameters, such as the rpm of the pump **18**, or the motor **22** or the modulating frequency of a solenoid valve. In one mode of operation, the wellsite controller **80** periodically polls the meter **20** and automatically

adjusts the pump controller **22** via an analog input **22a** or alternatively via a digital signal of a solenoid controlled system (pneumatic pumps). The controller **80** also can be programmed to determine whether the pump output, as measured by the meter **20**, corresponds to the level of signal **22a**. This information can be used to determine the pump efficiency. It can also be an indication of a leak or another abnormality relating to the pump **18**. Other sensors **94**, such as vibration sensors, temperature sensors may be used to determine the physical condition of the pump **18**. Sensors which determine properties of the wellbore fluid can provide information of the treatment effectiveness of the additive being injected, which information can then be used to adjust the additive flow rate as more fully described below in reference to **Figure 3**. The remote controller **82** may control multiple onsite controllers via a link **98**. A data base management system **99** may be provided for the remote controller **82** for historical monitoring and management of data. The system **10** may further be adapted to communicate with other locations via a network (such as the Internet) so that the operators can log into the database **99** and monitor and control additive injection of any well associated with the system **10**.

Figure 1A shows an alternative manner for controlling the additive

pump. This configuration includes a control valve, such as a solenoid valve **102**, in the supply line **106** from a source of fluid under pressure (not shown) for the pump controller **22**. The controller **80** controls the operation of the valve via suitable control signals, such as digital signals, provided to the valve **102** via line **104**. The control of the valve **22** controls the speed or stroke of the pump **18** and thus the amount of the additive supplied to the wellbore **50**. The valve control **102** may be modulated to control the output of the pump **18**.

The automated modes of operation (both local and/or from the remote location) of the injection system **10** are described above. However, in some cases it is desirable to operate the control system **10** in a manual mode, such as by an operator at the wellsite. Manual control may be required to override the system because of malfunction of the system or to repair parts of the system **10**. **Figure 1B** shows a circuit **124** for manual control of the additive pump **18**. The circuit **124** includes a switch **120** associated with the controller (see **Figure 1**), which in a first or normal position (solid line **22b**) allows the analog signal **22a** from the controller to control the motor **22** and in the second position (dotted line **22c**) allows the manual circuit **124** to control the motor **22**. The circuit **124**, in one configuration, may include a current control circuit, such as a

rheostat **126** that enables the operator to set the current at the desired value. In the preferred embodiment, the current range is set between 4 and 20 milliamperes, which is compatible with the current industry protocol. The wellsite controller is designed to interface with manually-operated portable remote devices, such as infrared devices. This allows the operator to communicate with and control the operation of the system **10** at the well site, e.g., to calibrate the system, without disassembling the wellsite controller **80** unit. This operator may reset the allowable ranges for the flow rates and/or setting a value for the flow rate.

As noted above, it is common to drill several wellbores from the same location. For example, it is common to drill 10-20 wellbores from a single offshore platform. After the wells are completed and producing, a separate pump and meter are installed to inject additives into each such wellbore. **Figure 2** shows a functional diagram depicting a system **200** for controlling and monitoring the injection of additives into multiple wellbores **202a-202m** according to one embodiment of the present invention. In the system configuration of **Figure 2**, a separate pump supplies an additive from a separate source to each of the wellbores **202a-202m**. Pump **204a** supplies an additive from the source **206a**. Meter **208a** measures the flow rate of the additive into the wellbore **202a** and provides

corresponding signals to a central wellsite controller **240**. The wellsite controller **240** in response to the flow meter signals and the programmed instructions or instructions from a remote controller **242** controls the operation of pump control device or pump controller **210a** via a bus **241** using addressable signaling for the pump controller **210a**. Alternatively, the wellsite controller **240** may be connected to the pump controllers via a separate line. Furthermore, a plurality of wellsite controllers, one for each pump may be provided, wherein each such controller communicating with the remote controller **242** via a suitable communication link as described above in reference to **Figure 1**. The wellsite controller **240** also receives signal from sensor **S1a** associated with pump **204a** via line **212a** and from sensor **S2a** associated with the pump controller **210a** via line **212a**. Such sensors may include rpm sensor, vibration sensor or any other sensor that provides information about a parameter of interest of such devices. Additives to the wells **202b-202m** are respectively supplied by pumps **204b-204m** from sources **206b-206m**. Pump controllers **210b-210m** respectively control pumps **204b-204m** while flow meters **208b-208m** respectively measure flow rates to the wells **202b-202m**. Lines **212b-212m** and lines **214b-214m** respectively communicate signals from sensor $\mathbf{S_{1b}}$-$\mathbf{S_{1m}}$ and $\mathbf{S_{2b}}$-$\mathbf{S_{2m}}$ to the central controller **240**. The controller **240** utilizes memory **246** for storing data in memory **244** for storing

programs in the manner described above in reference to system **10** of **Figure 1**. A suitable two-way communication link **245** allows data and signals communication between the central wellsite controller **240** and the remote controller **242**. The individual controllers would communicate with the sensors, pump controllers and remote controller via suitable corresponding connections.

The central wellsite controller **240** controls each pump independently. The controller **240** can be programmed to determine or evaluate the condition of each of the pumps **204a-204m** from the sensor signals S_{1a}-S_{1m} and S_{2a}-S_{2m}. For example the controller **240** can be programmed to determine the vibration and rpm for each pump. This can provide information about the effectiveness of each such pump. The controller **240** can be programmed to poll the flow rates and parameters of interest relating to each pump, perform desired computations at the well site and then transmit the results to the remote controller **242** via the communication link **248**. The remote controller **242** may be programmed to determine any course of action from the received information and any other information available to it and transmit corresponding command signals to the wellsite central controller **240**. Again, communication with a plurality of individual controllers could be done in a suitable

corresponding manner.

Figure 3 is a schematic illustration of wellsite remotely-controllable closed-loop additive injection system **300** which responds to measurements of downhole and surface parameters of interest according to one embodiment of the present invention. Certain elements of the system **300** are common with the system **10** of **Figure 1**. For convenience, such common elements have been designated in **Figure 3** with the same numerals as specified in **Figure 1**.

The well **50** in **Figure 3** further includes a number of downhole sensors $\mathbf{S_{3a}}$-$\mathbf{S_{3m}}$ for providing measurements relating to various downhole parameters. Sensor $\mathbf{S_{3a}}$ provide a measure of chemical characteristics of the downhole fluid, which may include a measure of the paraffins, hydrates, sulfides, scale, asphaltenes, emulsion, etc. Other sensors and devices $\mathbf{S_{3m}}$ may be provided to determine the fluid flow rate through perforations **54** or through one or more devices in the well **50**. The signals from the sensors may be partially or fully processed downhole or may be sent uphole via signal/date lines **302** to a wellsite controller **340**. In the configuration of **Figure 3**, a common central control unit **340** is preferably utilized. The control unit is a microprocessor-based unit and

includes necessary memory devices for storing programs and data and devices to communicate information with a remote control unit **342** via suitable communication link **342**.

The system **300** may include a mixer **310** for mixing or combining at the wellsite a plurality of **additive #1 - additive #m** stored in sources **313a-312m** respectively. In some situations, it is desirable to transport certain additives in their component forms and mix them at the wellsite for safety and environmental reasons. For example, the final or combined additives may be toxic, although while the component parts may be non-toxic. Additives may be shipped in concentrated form and combined with diluents at the wellsite prior to injection into the well **50**. In one embodiment of the present invention, additives to be combined, such as additives **additive #1-additive #m** are metered into the mixer by associated pumps **314a-314m**. Meters **316a-316m** measure the amounts of the additives from sources **312a-312m** and provide corresponding signals to the control unit **340**, which controls the pumps **314a-314m** to accurately dispense the desired amounts into the mixer **310**. A pump **318** pumps the combined additives from the mixer **310** into the well **50**, while the meter **320** measures the amount of the dispensed additive and provides the measurement signals to the controller **340**. A second additive required to be injected into the well **50** may be stored in the source **322**,

from which source a pump **324** pumps the required amount of the additive into the well. A meter **326** provides the actual amount of the additive dispensed from the source **322** to the controller **340**, which in turn controls the pump **324** to dispense the correct amount.

The wellbore fluid reaching the surface may be tested on site with a testing unit **330**. The testing unit **330** provides measurements respecting the characteristics of the retrieved fluid to the central controller **340**. The central controller utilizing information from the downhole sensors $\mathbf{S_{3a}}$-$\mathbf{S_{3m}}$, the tester unit data and data from any other surface sensor (as described in reference to **Figure 1**) computes the effectiveness of the additives being supplied to the well **50** and determine therefrom the correct amounts of the additives and then alters the amounts, if necessary, of the additives to the required levels.

The controller also provides the computed and/or raw data to the remote control unit **342** and takes corrective actions in response to any command signals received from the remote control unit **342**. Thus, the system of the present invention at least periodically monitors the actual amounts of the various additives being dispensed, determines the effectiveness of the dispensed additives, at least with respect to

maintaining certain parameters of interest within their respective predetermined ranges, determines the health of the downhole equipment, such as the flow rates and corrosion, determines the amounts of the additives that would improve the effectiveness of the system and then causes the system to dispense additives according to newly computed amounts. The models **344** may be dynamic models in that they are updated based on the sensor inputs.

Thus, the system described in **Figure 3** is a closed-loop, remotely controllable additive injection system. This system may be adapted for use with a hydrocarbon processing unit **75** at the wellsite or for a pipeline carrying oil and gas. The additive injection system of **Figure 3** is particularly useful for subsea pipelines. In oil and gas pipelines, it is particularly important to monitor the incipient formation of hydrates and take prompt corrective actions to prevent them from forming. The system of the present invention can automatically take broad range of actions to assure proper flow of hydrocarbons through pipelines, which not only can avoid the formation of hydrates but also the formation of other harmful elements such as asphaltenes. Since the system **300** is closed loop in nature and responds to the in-situ measurements of the characteristics of the treated fluid and the equipment in the fluid flow path, it can

administer the optimum amounts of the various additives to the wellbore or pipeline to maintain the various parameters of interest within their respective limits or ranges, thereby, on the one hand, avoid excessive use of the additives, which can be very expensive and, on the other hand, take prompt corrective action by altering the amounts of the injected additives to avoid formation of harmful elements.

Figure 4 shows an alternative embodiment of the present invention wherein redundant additive pumps are used to inject additives. Certain elements in **Figure 4** are common with the additive injection and monitoring system of **Figure 1** and those common elements have been designated within **Figure 4** with the same numerals as specified in **Figure 1**. In **Figure 4**, two additive pumps (**18a** and **18b**) are piped such that they both can pump additives from a additive source (**16**) through a common header (**424**) having check valves (**425** and **425a**) through a flow meter (**20**) and then into wellbores, wellsite hydrocarbon processing units pipelines and additive processing units at a selected flow rate as set forth in Figure 1. In the embodiment set forth in this Figure 4, the onsite controller (**80**), after control signals to the additive pump in service (*e.g.* **18a** or **18b**) fails to result in an acceptable flow rate of additive, turns off the additive pump in service and turns on the redundant pump (*e.g.* **18b** or **18a**, respectively). The onsite controller (**80**) then sends a signal via

the data link (**85**) to the remote controller (**82**) which in turn sends a signal via the network to notify a remote attendant that pumps in the system need service. In yet another embodiment, a remote attendant or computer can send a signal (not shown) to the onsite controller (**80**) to rotate use between the additive pumps (**18a** and **18b**) for maintenance purposes.

While the foregoing disclosure is directed to the preferred embodiments of the invention, various modifications will be apparent to those skilled in the art. It is intended that all variations within the scope and spirit of the appended claims be embraced by the foregoing disclosure.